Quality Control

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CONFORI	MANCE / UP	PDATE	QA Closed:	Date:	٠.
					DISPOSITION		· · · · · · · · · · · · · · · · · · ·	AGAINST DE			-
Work Orde	er:							AGAINST DE	, AKTIVICIAT	, . NOCE33	. —
Part N	lo		-		Rework Scrap Use-as-is	1 1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo			<del> </del>	Work Order Update	i ilen	Large Fab	Composite	, nec/stol	Supplier	
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data			1		·						
Equip/Tooling			l								
Operator		1									
Material									et.		
Setup											
Other									,		
Process											,
Supplier											
Training											
Unapproved									<u> </u>		<u> </u>
						AULT CATE	GORY				
Landi	ng Gear				General			_	7	_	<b>1</b>
	Bending				Bend	Grain			Ovalized	_	Pressure/Forced
		ot Conce	ntric to	o/s	BOM/Route	Hardwa			Over/Under	—	Temperature/Cure
	Cracks				Broken/Damaged	⊢ :	ion Incomplete		Part Incorre	<del></del>	Weld
		/Crimped	-	<u> </u>	Burrs	<del></del>	tions Incomplete,	/Unclear	Part Lost/M	<u> </u>	Wrong Stock Pulled
•	Cuffs				Contamination	<b>⊢</b>	enance		Part Moved		
. [	Heat Tre	at			Countersink	Mislab	eled		Positioned V		7
	Inspection	n Strip in	Tube		Cụt Too Short	Misrea	d		Power Loss/	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord October-07-13		)7936		*10	793	16*						Page 2	2 ,
Item ID: Revision ID:	D2933-2			Accept	*N	1900	<b>040</b>	100	<b>)*</b> s	Setup Star	ı Vı	S1* S2*	
Item Name: Start Date: Required Date: Reference:	206 Saddle R 10/07/13 : 10/07/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*			Cust Item II Customer:	D:					<b>S</b> Z"	•
Approvals:		an:		_			nte:		F	Run Star Sto	1/1	R1* R2*	•
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	<del></del>
*130 *130* QC Quality Control		QC8- Inspect parts - seco	and check	0.00	۵.۵	15/10	15		4	<u></u> \$		0A5 08 	
*140 *140  *HandFinish  Hand Finishing		Chemical Conversion Co Memo	oat per QS1005 4.1	0.00					4	H	B107	5	1 4 1
150 <b>*150*</b> Powdercoat		White Gloss(Ref. 4.3.5.1)	) per QS1005 4.3-Alum	0.00					4	9	13-1	0-16	. D.

Memo

Powder Coating

STARETUME: OVER MPERATURE:

PINISH TIME:

	DQA:	Date:	
NON CONFORMANCE / LIDDATE			

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE** 

									QA Closed:	Date	•
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	Fab Prod. Eng. Coor. Q		
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material [											
Setup [											
Other											
Process											
Supplier											
Training											
Unapproved		<u> </u>				<u> </u>				l	
					F.	AULT CATE	GORY				
Landir	ng Gear				General				1	۔	
,	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Concer	ntric to (	D/S	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instruc	tions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
.	Cuffs				Contamination	Mainte	enance		Part Moved		
·- [	Heat Trea	at		<u> </u>	Countersink	Mislab	eled		Positioned V	Vrong _	_
ic [	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
-	Ripples in	n Bend			Drill Holes	Offset					
	Torque W	/aves in E	xtrusion	١ [	Drawing	Out of	Calibration				
	Turning S	equence			Finish	Out of	Sequence				
[	Mayo/Tu	ict in Tub	30		Folio	Outside	Dimonsions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 107936 \*107936\* Page 3 October-07-13 9:02:42 AM Item ID: D2933-2 Accept \*N900040100\* Setup Start Revision ID: 206 Saddle Right Item Name: Start Oty: 4.00 **Start Date:** 10/07/13 **Cust Item ID: Req'd Oty:** 4.00 Required Date: 10/07/13 **Customer:** Reference: Run Process Plan: Tooling: Date: Date: Approvals: Stop SPC (Y/N): Date: QC: Date: Tool ID Tool # Plan Accept Reject Reject Insp. Sequence ID/ Operation Set Up/ **Work Center ID** Description Number Stamp Code Qty Qty **Run Hours** QC3- Inspect Part Finish 0.00 160 \*160\* DAS 27 0.00 Memo 9.89 Quality Control 13-10-16 170 Identify as per dwg & Stock Location: 5T437 0.00HX 28 13-10-16 \*170\* 0.00 Packaging Memo Packaging 11/12/13-10-17 MB-10-17 OC21- Final Inspection - Work Order Release 0.00 180 \*120\* QC 0.00 Memo Quality Control

DQA:		Date:	<u> </u>
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NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

							ξ.		QA Closed:	Dat	te:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	0			Scrap Machining Small Fab Prod. Eng. Coor Use-as-is Thermoforming Finishing Rec/Store/Packaging							Engineering Quality Other
Root		1	1	Descri	ption of work order update	Initial	Τ Δ.	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er		cription	Date	Verification	n QC Inspector
Doc/Data	Date	эсер	Qty	<u>`</u>	or Non comormance	Criter El	16 003	cription	Date	Vermeation	Qe mspector
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process							·				
Supplier											
Training											
Unapproved										1	
	•	• • •			F.	AULT CA	regory				
Landin	g Gear	23			General						
	Bending	•			Bend	Grain	า		Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to C	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete	:	Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instr	uctions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	ntenance		Part Moved		
	Heat Trea	it			Countersink	Misla	beled		Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short	Misre	ead		Power Loss/	'Surge	Other
	Ripples in	Bend			Drill Holes	Offse	t				
	Torque W	aves in E	extrusion		Drawing	Out	of Calibration				
	Turning S	equence			Finish	Out	of Sequence				
Γ	Wave/Tw	ist in Tub	10		Teolio	Outs	de Dimensions				•

**Picklist Print** 

October-07-13 9:02:41 AM

Work Order ID:

107936

Parent Item:

Comments:

D2933-2

Parent Item Name:

206 Saddle Right

IPP: B00.06.26New DWG rev (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

**Start Date: 10/07/13** 

Required Date: 10/07/13

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	16.0000	1 4	4	S\$ 13-	10-11	
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				MAT042		16			<u> </u>				
				1036	37	3							
				9723	9	13			_4	<u>/</u>			

Page 1

DQA:

Date:

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
									·		QA Closed:	Date	:
Nork Ord	ler:					DISPOSITION			,	AGAINST DE	PARTMENT	/PROCESS	
						Rework	]	Skid-tube Crosstube			]	Water Jet	Engineering
Part	No.					Scrap		ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			-		_	Use-as-is		•	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	No.					Work Order Update	ן נ		Large Fab	Composite		Supplier	_
Root					Descr	ription of work order update	T	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	1 .	or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling	L	] .	,		1								
perator	L						`			,			
laterial	$oxed{\!$	1											
etup	_	<u> </u>											
ther	$ldsymbol{le}}}}}}$												
rocess	L						İ						,
upplier	<u>_</u>							٠					
raining	<u> </u>			1		•							
napproved	<u> </u>	<u> </u>	<u> </u>	<u> </u>	<u> </u>			T 64 TF				<u> </u>	
							AUL	T CATE	JORY				
Land	ing (	7				General		Grain			Ovalized	Г	Pressure/Forced
	-	Bending	- <b>.</b> C		o/s	Bend BOM/Route	-	1		-	4	talaranca	Temperature/Cure
	$\vdash$	Centre No	ot Concei	ntric to	<sup>0/3</sup>  -	BOM/Route	$\vdash$	Hardwa			Over/Under Part Incorred	<del>-</del>	Weld
	-	Cracks Crushed/	د اسم ما		$\vdash$	Broken/Damaged	-	1	on Incomplete ions Incomplete/	/Unclose	Part Lost/Mi	<del> -</del>	Wrong Stock Pulled
	$\vdash$	Cuffs	сппреа.	•	-	Contamination	$\vdash$	Mainte		Officieal	Part Moved	22118	
	-	Heat Trea	.+		-	Countersink	-	Mislabe		-	Positioned V	Vrong	
	$\vdash$	Inspection		Tubo		Cut Too Short	$\vdash$	Misread			Power Loss/		Other
	$\vdash$	Ripples in		Tube	-	Drill Holes	-	Offset	ı	<u>L</u> .	J. OWEL LOSS/	Juige [	Other
	$\vdash$	Torque W		vtrucio	<u>,</u>	Drawing	-	4	Calibration				
	$\vdash$	Turning S			" ⊦	Finish	$\vdash$	4	Sequence				
	$\vdash$	Wave/Tw			$\vdash$	Folio	$\vdash$	1	Dimensions				
	1	1 44 GACY I AN	ISCHI IUL	,.	i	11 0110	1	Journal	Dirichsions				

DART AEROSPACE LTD	Work Order:	107936
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Red	orded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		124	126	1124	.127		
В	0.100	0.140		126	126	12/	.127		
С	0.100	0.140		223	123	123	.123		
D	0.210	0.230		.223	.223	. 223	224		
E	1.245	1.255		1,250	1.250	1,250	1.250		
F	1.245	1.255		1250	1,250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2,500		
H	0.510	0.515		.572	.572	.572	.572		
1	1.572	1.582	-	1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2,500		
K	0.257	0.262		.260	.21.0	.21.0	-260		
<u> </u>	0.312	0.317		314	.314	.314	.314		
M	0.235	0.240		.23%	.234	236	.231		
N	0.100	0.140		,121	.121	121	1/21		
0	0.540	0.560		542	548	.548	.548		
P	0.490	0.510		.5n0	.500	.500	. 500		
Q	3.715	3.725	,	3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		-
S	0.240	0.270	1	.254	255	.254	.254		
T	0.100	0.180	,	.140	./38	.138	./3%		
Ū	1.625	1.635		1.1.30	1.630	1.1.30	1.630		
$\overline{v}$	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		3/7	.3/7	.3/2	.3/2		
X	1.125	1.145		1135	1.135	1.1355	1.735		
Y	1.565	1.585	DT8695 A/B	1.574	1575	1.574	1.574		
Z	0.178	0.198		1.188	./88	1188	.188		
ĀĀ							/		
AB									
AC									
AD									
AE			† <del></del>						
AF	<b> </b>		<u> </u>						
AG									
AH			,	<u> </u>					
	Acc	cept/Reje			~				

			$ \sigma \phi \phi$
Measured by:	Sil	Audited by h	700
Date:	13/10/10	Date: 13110115	888
Date.	13/10/12	39.5.1.311011	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
С	07.03.21	Revised per drawing revision C	KJ/JLM OK	\(\( \sqrt{\pi} \) \( \)
C	07.03.21	Revised per drawing revision C	NJ/JEIVI	1978

